

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011161**Date Inspected:** 29-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Chen ying xin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no. 10

1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040491 perform SMAW repair welding on, spare strut stiffener to web, weld joint identified as ND1-STSA3-1-99M-1-33, 34. ZPMC CWI Identified as Mr. Chen ying xin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2113.

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 057220 perform SMAW welding on, Skirt plate, weld joint identified as ND1-A 501 E/E-36. ZPMC CWI Identified as Mr. Chen ying xin. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2314-b-p3.

Bay no. 11

3.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 048810 perform FCAW repair welding on, interconnecting splice plate, weld joint identified as WSD1-SPSA4-3-4A. ZPMC CWI Identified as Mr. An qing xiang. The welding parameters as measured using QC's calibrated

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

instruments appeared to be in general compliance with WPS-345-FCAW-2G (2G)-Repair.

4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 040713 perform FCAW welding on, CD corner diagonal plate, inside East tower, Lift 4, weld joint identified as ESTL4-2 B/L-7. ZPMC CWI Identified as Mr. Yu liang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2332-TC-P4-F.

Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report for this date. The member is identified as spare struts at Bay no. 10 & 11. The weld designations reviewed are as follows:

SD1 –A 6002 -15 – Jt. nos – 7,8,3,33,34 – Spare strut
ND1 –A 6002 -7 – Jt. nos – 23,31,32,7,8– Spare strut
ESTL4 -2 B/L – Jt. no. -59 A/B – East lift 4, AB corner
ESTL4 -2 B/L – Jt. no. -21,19 – East lift 4, BC corner triangular plate
ESTL4 -2 C/L – Jt. no. -18, 16 – East lift 4, BC corner triangular plate

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge, Sinevod - 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Baskar,Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
